

Date: Monday, 3/19/2007 4:38:53 PM
User: Kim Johnston

Process Sheet

split
07/03/28

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: DOOR ASSEMBLY
Job Number	: 31302-2		
Estimate Number	: 11403		
P.O. Number	: <i>N/A</i>	Part Number	: D3296041
This Issue	: 3/19/2007 S.O. No. : <i>N/A</i>	Drawing Number	: D3296 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision	: A
Previous Run	: 30608	Material	: <i>N/A</i>
Written By	:	Due Date	: 3/30/2007
Checked & Approved By	: <i>07.03.20</i>	Qty:	<i>14</i> Um: Each
Comment	: Est. C 05/10/14 Added step 14 KJ/EC Est Rev:D Revised Steps 06-11-20 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D32961	Door Panel
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Door Panel

Pick:

Qty	Part Number	Description	Batch
1	D3296-1	Door Panel	<i>B 31344</i>

FF 07-04-13 10

2.0	D32963	Door Panel
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Door Panel

Pick:

Qty	Part Number	Description	Batch
1	D3296-3 Door	Panel	<i>B 31345</i>

FF 07-04-13 10

3.0	D31617	Hinge 14"
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Hinge 14"

Batch: *B 31340*

FF 07-04-13 10

4.0	D31619	Hinge 17"
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Hinge 17"

Batch: *B 31341*

FF 07-04-13 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 3/19/2007 4:38:53 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 31302

Part Number: D3296041

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

MS20470AD44

Rivet, Universal Head



Comment: Qty.: 25.0000 Each(s)/Unit Total: 250.0000 Each(s)

Rivet, Universal Head

Batch: 17103446

FF 07-04-13 10

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Fabricate & assemble as per Dwg D3296.

FF 07-04-17 10

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07-04-17 (10)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

07-04-19 (10)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10.0

D2137

Decal - No Step



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Decal - No Step

Pick:

Qty Part Number Description Batch

1 D2137 Decal B31330

✓

11.0

D2419

Handle



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Handle

Pick:

Qty Part Number Description Batch

1 D2419 Handle B30913

✓
ml 07/04/20

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Date: Monday, 3/19/2007 4:38:53 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 31302

Part Number: D3296041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D24620040

Seal



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Seal

Pick:

Qty Part Number Description Batch

1 D2462-0040 Seal

B29456

✓

13.0

D24620053

Seal



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Seal

Pick:

Qty Part Number Description Batch

1 D2462-0053 Seal

B29456

✓

14.0

D24620245

Seal



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Seal

Pick:

Qty Part Number Description Batch

1 D2462-0245 Seal

B29456

✓

15.0

D27281

Dart Logo label small



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Dart Logo label small

Pick:

Qty Part Number Description Batch

1 D2728-1 Decal

B24215

✓

16.0

AN960JD6

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Washer

Pick:

Qty Part Number Description Batch

1 AN960JD6 Washer

M6085

✓
mel 07/04/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/04/24

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 31302

Part Number: D3296041

Job Number:



Seq. #:

Machine Or Operation:

Description:

17.0

MS20470AD46

Rivet, Universal Head



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Rivet, Universal Head

Pick:

Qty Part Number Description Batch

1 MS20470AD4-6 Rivet

M103691

ml 07/04/20

18.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3296

ml 07/04/23

x10

19.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

20704.24 (10)

20.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

20704.24 (10)

21.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

20704.24 (10)

Job Completion



20704.24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

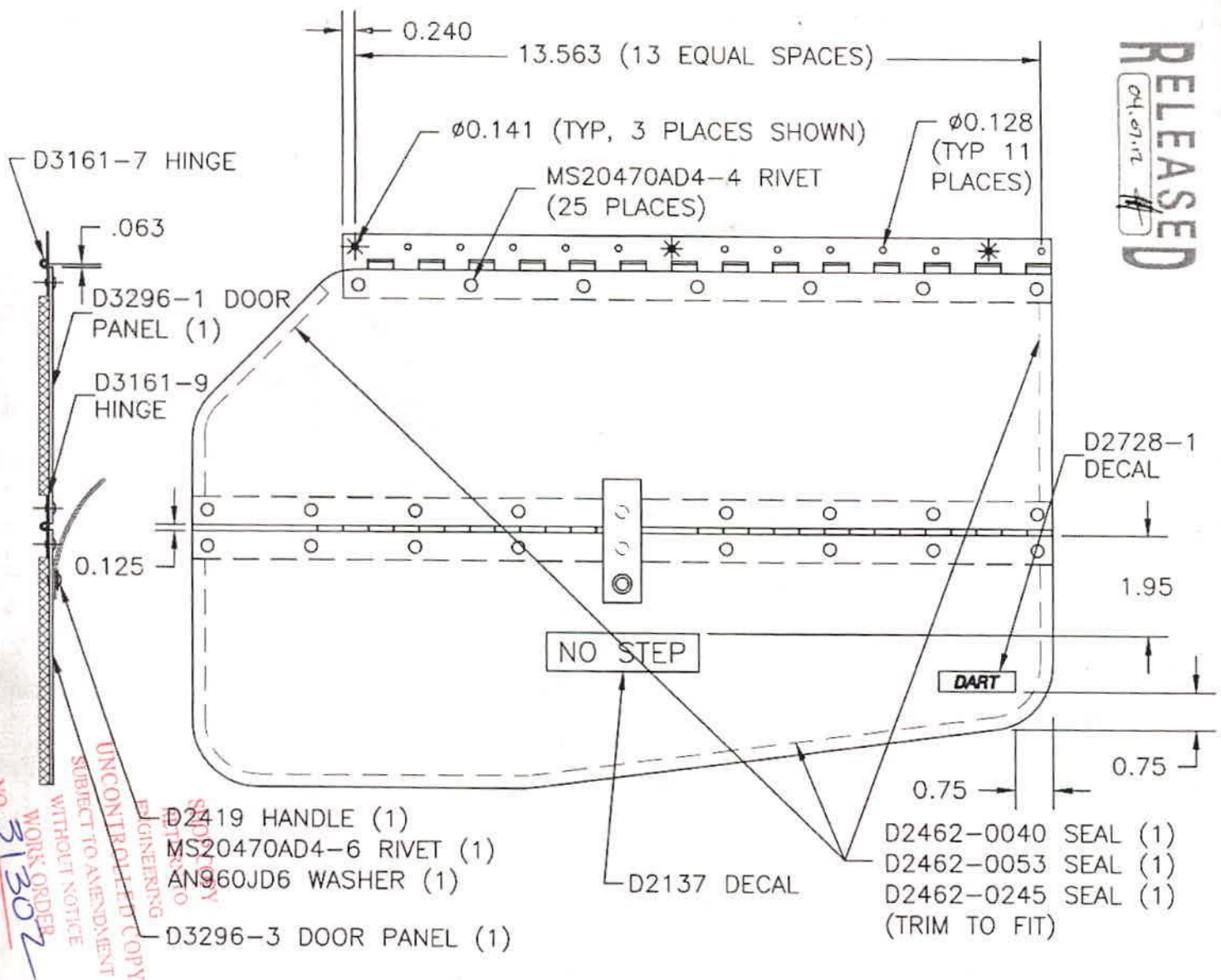
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN		DRAWN BY		DART AEROSPACE LTD	
C/P		C/P		HAMKESBURY, ONTARIO, CANADA	
CHECKED		APPROVED		DRAWING NO.	REV. A
DATE	04.06.28			D3296	1 OF 2
				TITLE	SCALE
				DOOR ASSEMBLY	1:3
A		04.06.28		NEW ISSUE	

RELEASED
04.07.12



D3296-041 DOOR ASSEMBLY

- 1) FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) INSTALL D2137 & D2728-1 DECALS, D2419 HANDLE, AND D2462 SEALS AFTER POWDER COAT
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
NO. 31302
WORK ORDER

